Date:

Wednesday, 25/04/2007 2:13:41 PM

User:

Linda Lacelle

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number** : 32070

P.O. Number

: 10352 AIG:

This Issue Prsht Rev.

First Issue

: 25/04/2007

S.O. No. : NIK

: 31407A

: MACHINED PARTS

Previous Run Written By

Checked & Approved By

Comment

: Est Rev:A

New Issue

JLM

Drawing Name

: SPACER

Part Number

Drawing Number Project Number

D2280 REV D : N/A

: D2280

Drawing Revision

Material **Due Date**

NA : 02/05/2007

Qty:

Um:

Each

Additional Product

Job Number:



Seq. #:

Description:

1.0

M6061T6B0250X01000

6061-T6 Bar .25" x 1.0"

Comment: Qty.:

0.2975 f(s)/Unit Total: 5.9493 f(s)

Material: 6061-T6 (QQ-A-250/8) 0.25" Thick (M6061T6B0.250x1.000)Identify as D2280

SHEAR

40



Batch: <u>M1823</u>7

Comment: SHEAR

Cut blank: (3.400") +/-0.020"

3.0

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine per folio D2280 and Dwg D2280

2-Deburr Then Tumble



Comment: INSPECT

PARTS AS THEY COME OFF MACHINE

5.0

SECOND CHECK

Comment: SECOND CHECK



3204.

Dart Aerospace Ltd

1	WORK ORDER C						
STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	STEP	STEP PROCEDURE CHANGE	STEP PROCEDURE CHANGE	STEP PROCEDURE CHANGE By	STEP PROCEDURE CHANGE By Date	STEP PROCEDURE CHANGE By Date Qty	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date: <u>67/05/</u> 0
			QA: N/C Closed:	Date:

NCR:			WORK ORI	DER NON-CONFORMANO	CE (NCR)		 				
		Description of NC	Corrective Action Section B Verification				Corrective Action Section B			Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector			
							1 1 1				
						<u>.</u>	!	1			
		• .					1				
							1				
·							1				
							1 1 1 1				

NOTE: Date & initial all entries

Wednesday, 25/04/2007 2:13:41 PM Date: Linda Lacelle User: **Process Sheet** Drawing Name: SPACER Customer: CU-DAR001 Dart Helicopters Services Job Number: 32070 Part Number: D2280 Job Number: Seq. #: Description: Machine Or Operation: HAND FINISHING1 6.0 HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: G. A QC21 FINAL INSPECTION/W/O RELEASE 9.0 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart Aerospace Ltd

W/O: WORK ORDER CHANGES							
DATE STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					-		
Part No		PAR #· Fault Category:	NCR: Yes	No DO	١.	Date:	

QA: N/C Closed: _____ Date: ____

NCR:	WORK ORDER NON-CONFORMANCE (NCR							
		Description of NC		Corrective Action Section B	· · · · · · · · · · · · · · · · · · ·	Verification	Annroval	Annrovol
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto
						1		
				·				
				·				

NOTE: Date & initial all entries

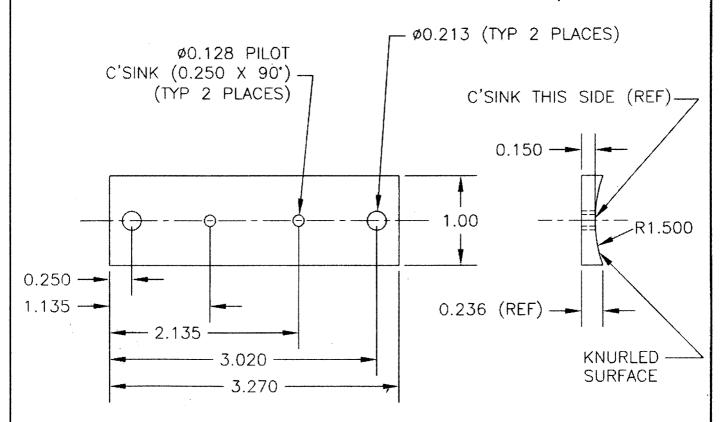


DESIG	d	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CANAD	
CHEC	KED M	APPROVED 4	DRAWING NO.	REV. D
	#	#	D2280	SHEET 1 OF 1
DATE			TITLE	SCALE
05.1	1.14		SPACER	1:1
Α		94.10.14	NEW ISSUE	ς.



05.	11.14	SPACER 1:1
Α	94.10.14	NEW ISSUE
В	95.03.22	MATERIAL CHANGE, 0.15 WAS 0.20
С	98.09.29	0.188 DIA HOLE CHANGED TO 0.213
D	05.11.14	'.ADD, FINISHING NOTE

w/237070



D2280 SPACER

- MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8) BAR, 0.250 X 1.000 (REF. DART SPEC M6061T6B1.000X00.250)
- ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART AEROSPACE LTD	Work Order:	9000
Description: Spacer	Part Number:	D2280
Inspection Dwg: D2280 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing	<u> </u>	Actual			Method of	
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
0.150	+/-0.010	./50				
0.236	+/-0.010	.227				
3.270	+/-0.010	3.271				
3.020	+/-0.010	3021				
2.135	+/-0.010	2.135				
1.135	+/-0.010	1.135				
0.250	+/-0.010	.249				
1.00	+/-0.030	.999				
Ø0.128	+0.005/-0.000	/30				
Ø0.213	+0.005/-0.000	.215				
C'sink 0.250 x 90°	+/-0.010	.249,48			-	
						·
						,

Mea	asured by:	J.L.	Audited by:	and	Prototype Approval:	N/A
	Date:	07/04/25	Date:	07/04/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.10.12	New Issue P/O D2582	KJ/JLM	
В	06.03.08	Dwg Rev changed	KJ/JLM ,	